



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

POSITIVE RECALL

EFFECTIVE DATE

RELEASED

9-89

AUTH

DATE

10-02-22

D5795-7

Job Sheet 206995



OK to release @ Rev A per ECN 20-521

Part No: D5795-7

Job Qty: 12 pcs

Part Name: Rib



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/20

Job Tracking No:

Created By: Linda Lacelle

Due Date: 3/13/20

Type: Stock

Description:

Note: DWG 5795 REV.A8 IPP REV.A NEW ISSUE 20.31.01 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	12 pcs	3/13/20		0.00 1.20	Large Fab - 1		
						Large Fab - 10		
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
						Large Fab - 9		
						Large Fab - 11 (Various)		
						Large Fab - 12		
110	QC 5	12 pcs	3/13/20		0.00 0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		



Container No: S256973



Part: D5795-7

Job No: 206995

Serial No/Batch: S256973

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/20/20

Plex 2/14/20 1:40 PM dart.lacelle.linda

120 Packaging 3-1 - Stock - B4B 12 pcs

3/13/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

130 QC 21 - SA

12 pcs

3/13/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

FEB 25 2020

Part Op 100 - 1- Cut as per dwg 2- Deburr

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Identify as per dwg & Stock Location: *WAB04*

130 - QC21- Final Inspection - Work Order Release

Job BOM

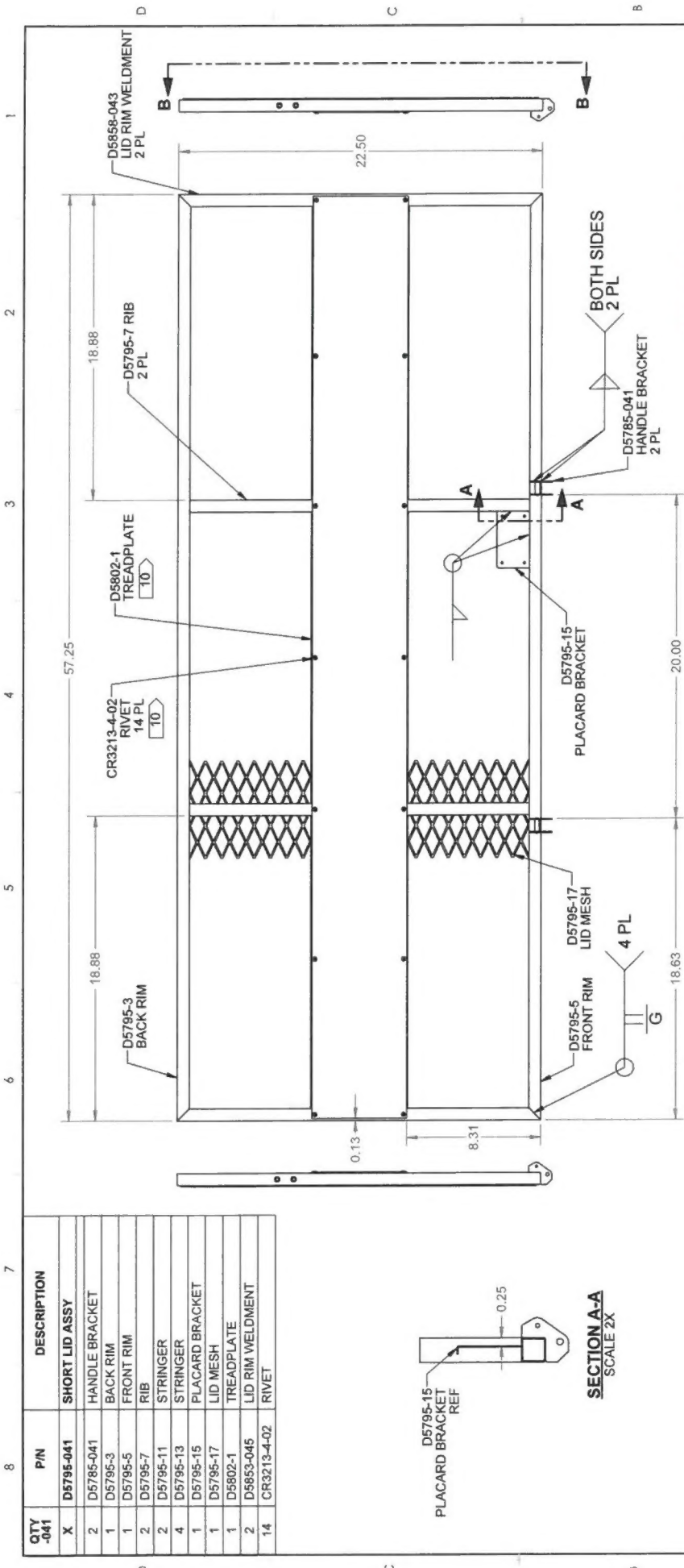
Part / Item	Component Name	Quantity	Operation	Container
M4130NTS0.750W.035	4130 Square Tube 0.750 X 0.035W	21.0996 ft (1.7583 ea)	100-Large Fab - Basket - 1	<i>S250 794</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	M4130NTS0.750W.035	21	609	0

Part Specifications

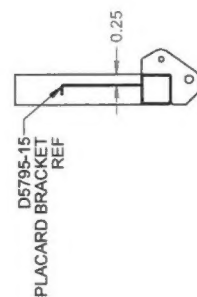
Specifications could not be found.



D5795-041 SHORT LID ASSY
(DERIVED FROM AERO DESIGN P/N 77612-01)
(MESH SHOWN LOCALLY FOR CLARITY)

PRELIMINARY ISSUE

QTY -041	P/N	DESCRIPTION
X	D5795-041	SHORT LID ASSY
2	D5785-041	HANDLE BRACKET
1	D5795-3	BACK RIM
1	D5795-5	FRONT RIM
2	D5795-7	RIB
2	D5795-11	STRINGER
4	D5795-13	PLACARD BRACKET
1	D5795-15	LID MESH
1	D5802-1	TREADPLATE
2	D5853-045	LID RIM WELDMENT
14	CR3213-4-02	RIVET



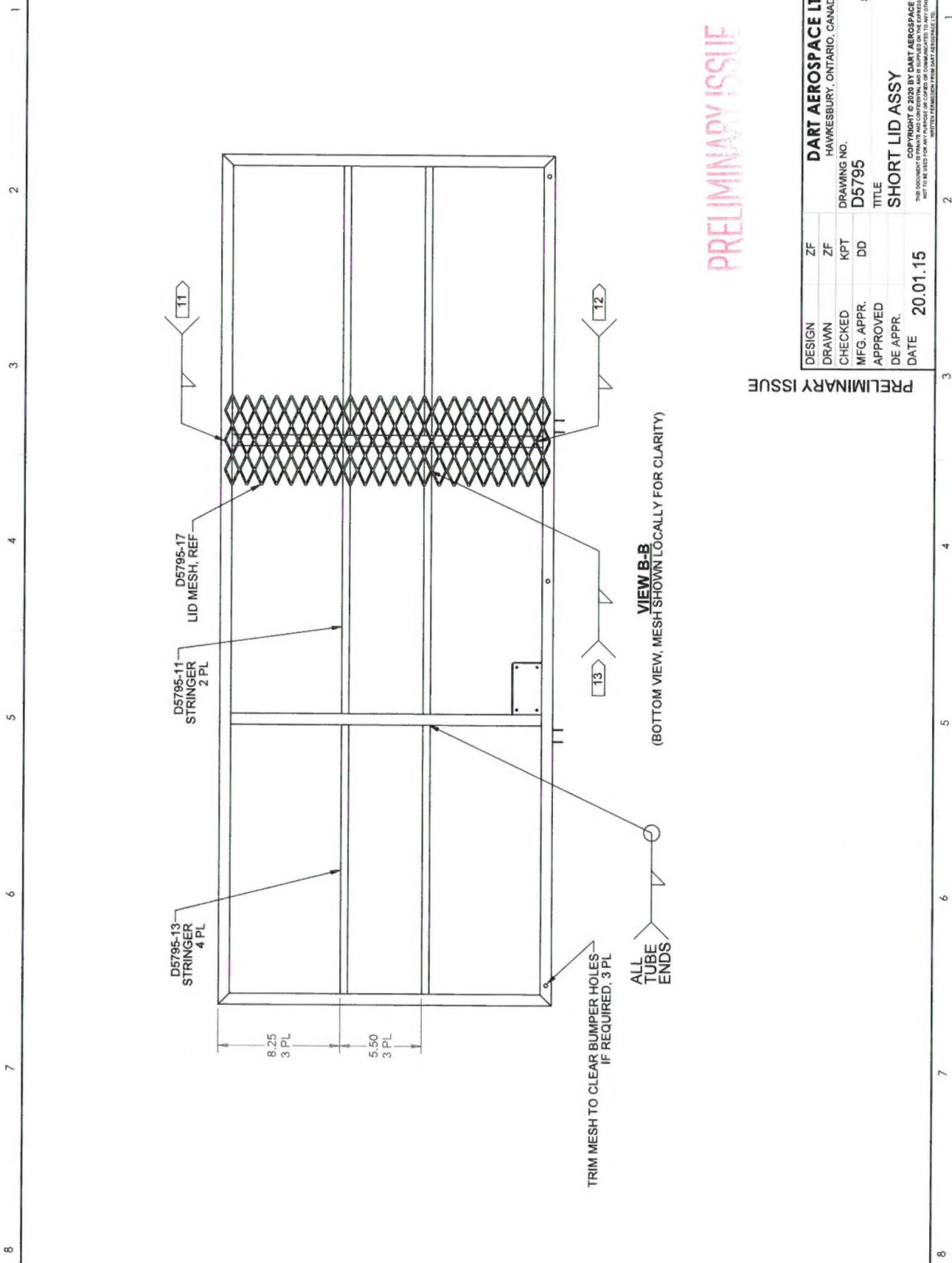
SECTION A-A
SCALE 2X

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5795-041" AND SERIAL NUMBER PER DART QSI 044 6.6
 - 7) WEIGHT: 14.15 lbs
 - 8) WELD PER DART QSI 004
 - 9) DRILL #30 (.00129) VENT HOLES AS REQUIRED. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD PRIOR TO FINISH.
 - 10) INSTALL TREADPLATE AFTER FINISH. TRANSFER MARK AND DRILL HOLES Ø.0129/0.132 FROM TREADPLATE TO LID. FAY SEAL TO SURFACES BETWEEN LID AND TREADPLATE WITH RTV SILICONE. SECURE TREADPLATE WITH RIVETS.
 - 11) WELD EVERY MESH INTERSECTION ALONG RIM.
 - 12) FOR EACH RIB, WELD FIRST 5 MESH INTERSECTIONS DOWN EACH END THEN EVERY 2ND MESH INTERSECTION.
 - 13) FOR EACH STRINGER, WELD EVERY 2ND MESH INTERSECTION.

PRELIMINARY ISSUE

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN	ZF				
DRAWN	ZF				
CHECKED	KPT				
MFG. APPR.	DD				
DE APPR.					
DATE	20.01.15				

DART AEROSPACE LTD		REV. A6
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 6
DRAWING NO. D5795		SCALE
TITLE		NTS
SHORT LID ASSY		
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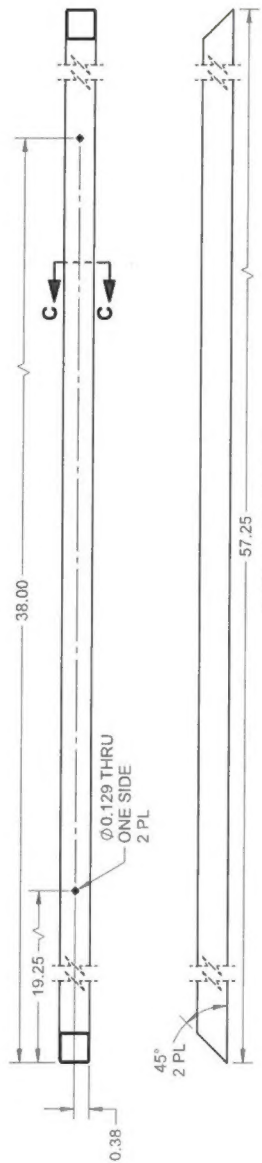


PRELIMINARY ISSUE

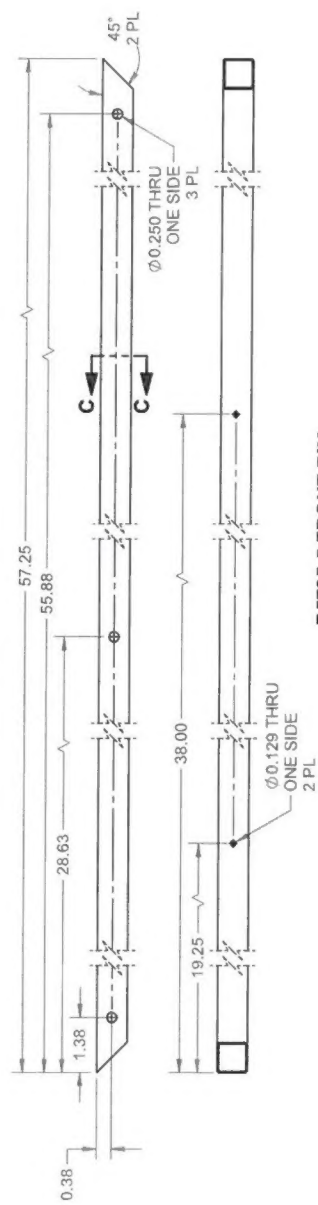
PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO. D5795
MFG. APPR.	DD	REV. A6 SHEET 2 OF 6
APPROVED		TITLE SHORT LID ASSY
DE APPR.		SCALE NTS
DATE	20.01.15	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



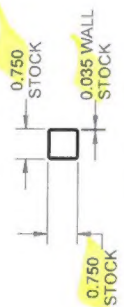
D5795-3 BACK RIM



D5795-5 FRONT RIM



D5795-7 RIB



SECTION C-C

PRELIMINARY ISSUE

PRELIMINARY ISSUE

- NOTES:
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL PER MIL-T-6736 OR AMS 6371/6370/6361/6362/6373/6374 REF DART SPEC M4130N-TS
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -3.45; 1.55 lbs
-7: 0.58 lbs

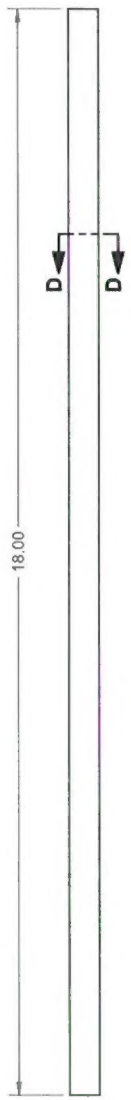
DESIGN	ZF	DART AEROSPACE LTD
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO.
MFG. APPR.	DD	D5795
APPROVED		TITLE
DE APPR.		SHORT LID ASSY
DATE	20.01.15	SCALE
		NTS

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8 7 6 5 4 3 2 1

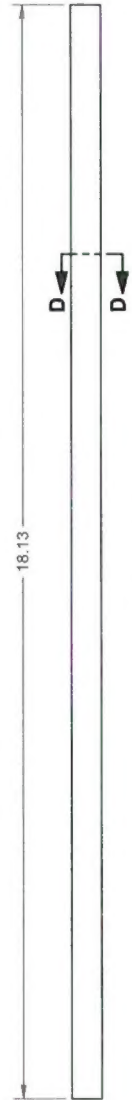
8 7 6 5 4 3 2 1

D C B A



D5795-11 STRINGER

SECTION D-D



D5795-13 STRINGER

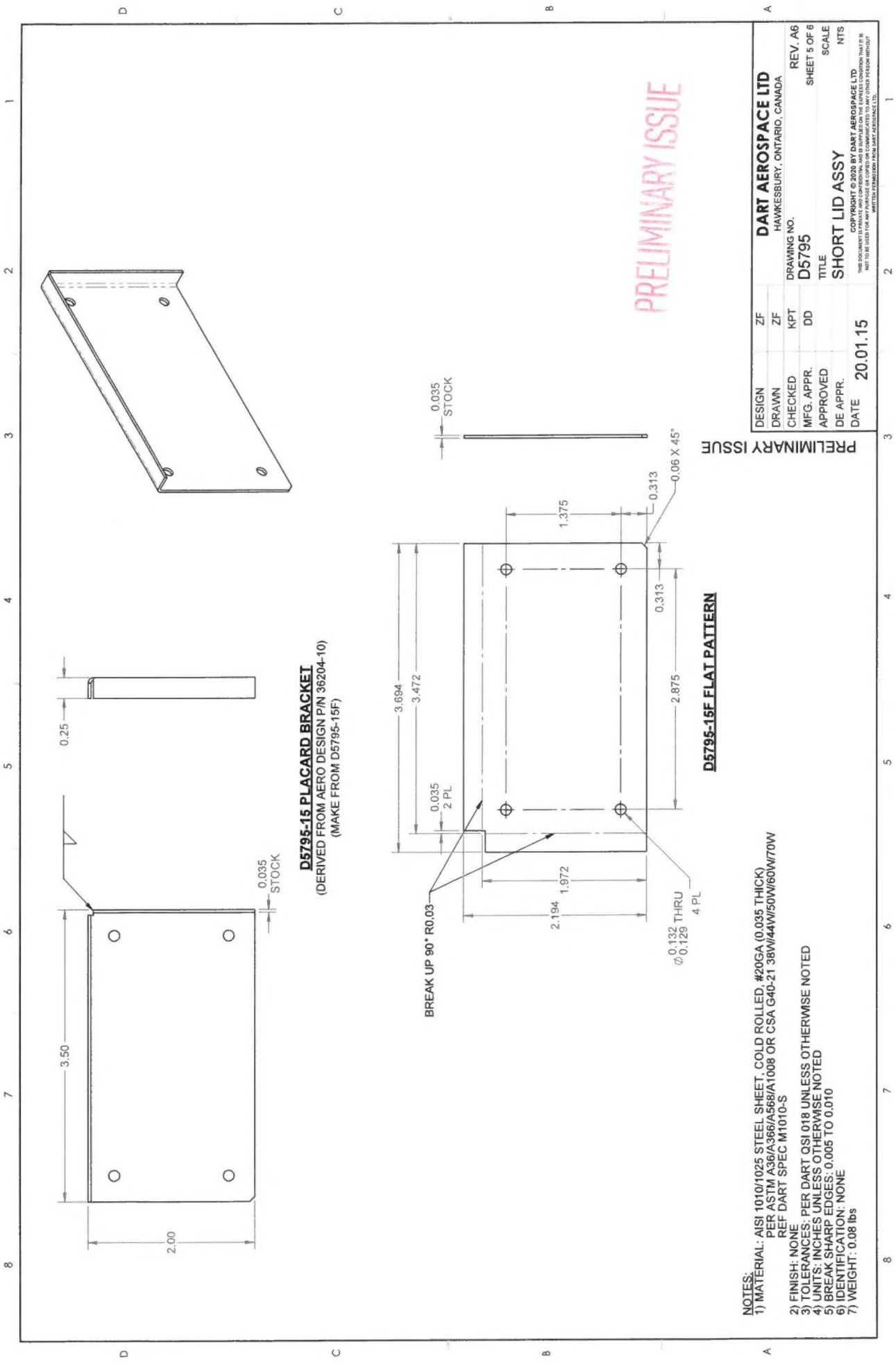
PRELIMINARY ISSUE

PRELIMINARY ISSUE

- NOTES:**
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL PER MIL-T-6736 OR AMS 6371/6370/6361/6362/6373/6374 REF DART SPEC M4130N-TS
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -11-13: 0.32 lbs

DESIGN	ZF	DART AEROSPACE LTD
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO. D5795
MFG. APPR.	DD	REV. A6
APPROVED		SHEET 4 OF 8
DE APPR.		SCALE
DATE	20.01.15	SHORT LID ASSY
		NTS

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DART AEROSPACE LTD.



D5795-15F PLACARD BRACKET
(DERIVED FROM AERO DESIGN P/N 36204-10)
(MAKE FROM D5795-15F)

PRELIMINARY ISSUE

D5795-15F FLAT PATTERN

DESIGN	ZF	ZF	DART AEROSPACE LTD
DRAWN	ZF	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED			DRAWING NO.
MFG. APPR.	DD		D5795
DE APPR.			TITLE
DATE	20.01.15		SHORT LID ASSY
			SCALE
			NTS

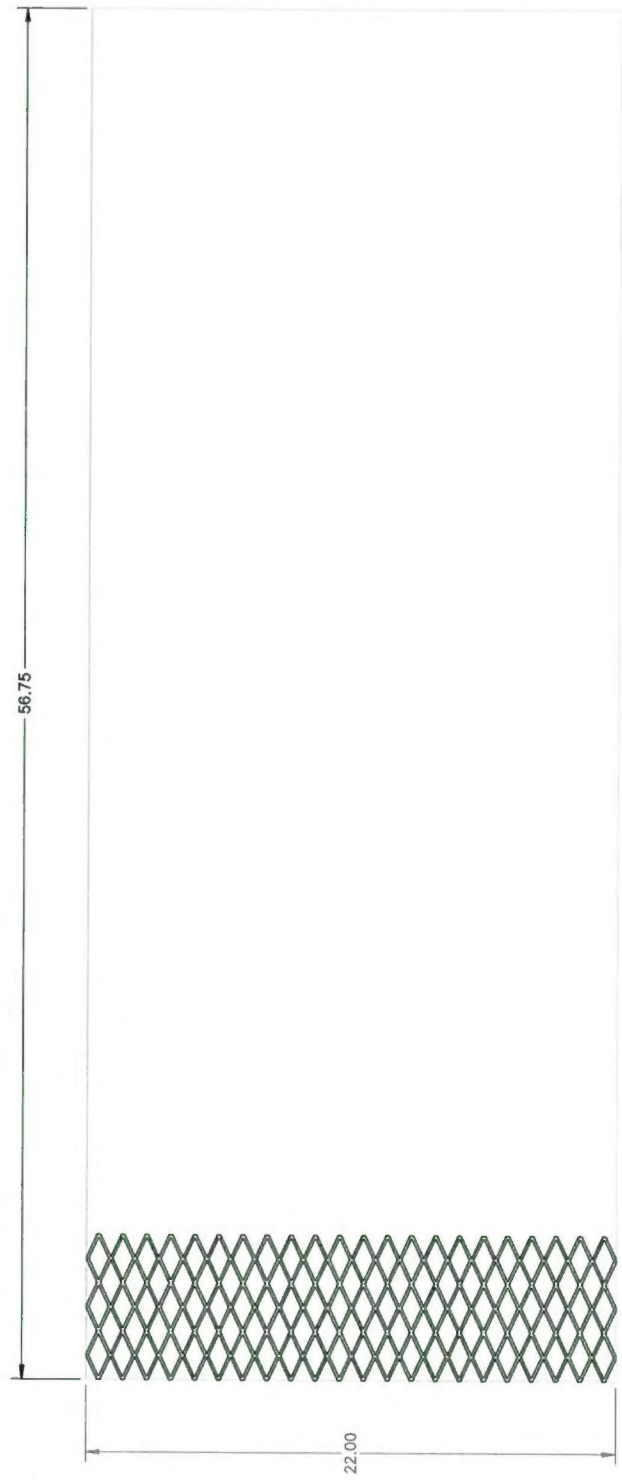
NOTES:
1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #20GA (0.035 THICK)
PER ASTM A36/A366/A568/A1008 OR CSA G40-21 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 0.08 lbs

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PRELIMINARY ISSUE

8 7 6 5 4 3 2 1

D C B A



D5795-17 LID MESH
(MESH SHOWN LOCALLY FOR CLARITY)

PRELIMINARY ISSUE

- NOTES:
- 1) MATERIAL: CARBON STEEL EXPANDED METAL MESH 3/4-16F PER ASTM F1267 OR MIL-M-17194D REF DART SPEC M569EX
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.56 lbs

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO.
MFG. APPR.	DD	D5795
APPROVED		TITLE
DE APPR.		SHORT LID ASSY
DATE	20.01.15	SCALE
		NTS

REV. A6
SHEET 6 OF 6

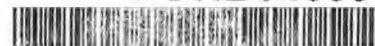
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045594



Supplier: FAC001-VU
Factory Steel
14020 Oakland Ave.
Detroit, MI 48203 USA
Phone: 313 883 6300
Fax: 313 883 4883

PO No: POHB045594

PO Date: 1/16/20

Due Date: 2/4/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

JAN 16 2020

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M4130NTS0.750W.065			4130 Square Tube 0.750 X 0.035W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed	-	2/4/20	600 ft	0 ft	600 ft	\$7.25/ft	\$4,350.00
2		M4130NTS1.000W.065			4130 Square Tube 1.000" X 1.000" X 0.065"W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed	-	2/4/20	160 ft	0 ft	160 ft	\$11.70/ft	\$1,872.00
												Grand Total: \$6,222.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POH5045594



Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/16/20 11:38 AM Dart.Lavoie.Chantal

PACKING LIST

No. 67371

PG 1 OF 1

PL

FACTORY STEEL & METAL SUPPLY 14020 OAKLAND AVENUE DETROIT, MI 48203		CUSTOMER PO POHB045594 CUSTOMER JOB		BUYER CHANTEL LAVOIE Tel (613) 632-3336 Fax (613) 632-4443		SHIP DATE 01/21/2020	
(313)883-6300 PHONE (313)883-4883 FAX		SALES ORDER 60306		ORDER DATE 01/16/2020		SHIP VIA ****TRUCK****	
SOLD TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SALES REP MEL HALL		RESALE # 59-2958719	
				SHIP INST CALL WHEN READY		CARRIER TRUCK	
				FRONT		BLIND Y/N N	
				TERMS NET 30 DAYS		FOB DETROIT	

LINE	QUANTITY	DESCRIPTION	WIDTH	LENGTH	WEIGHT
1	609.917 FT	4130N CD SMLSS SQ TUBE 3/4" X .035W Tag Mill Ref # Heat 153513 023679 616506	Pcs Length 26 20' /24' RL	20' /24' RL Feet 609.917	207.554 Weight 207.554
2	171.333 FT	4130N CD SMLSS SQ TUBE 1" X .065W Tag Mill Ref # Heat 153514 072143 072067859	Pcs Length 7 22' /23' RL	22' /23' RL Feet 171.333	141.606 Weight 141.606
3	1 PCS	PACKING CHARGES MTRS (CIRCLE) FAX SHIPMENT INVOICE ALL DATE: _____ INITIAL: _____			

TOTAL WT 349 LBS											
RECEIVED BY - SIGNATURE				RECEIVED BY - PRINTED NAME				DATE RECEIVED			

SO

LIVE 1
M4130NTS 0.750W.035

616506



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. M4130N-TS	REV. A SHEET 1 OF 1
DATE 05.02.09		TITLE 4130N SQUARE TUBING	SCALE NTS
A	05.02.09	NEW ISSUE	

PURCHASE MATERIAL:

AISI4130N STEEL SQUARE TUBING PER ONE OF
THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371,
6360, 6361, 6362, 6373 OR 6374

DAS
82
9-89

PART NUMBER:

M4130N-TS | A.AAA | W | .TTT |

WHERE A.AAA = WIDTH IN INCHES
TTT = WALL THICKNESS IN INCHES

EXAMPLE: 0.50" X 0.035" WALL = M4130N-TS0.500W.035

05.02.09 H



PLYMOUTH TUBE CO.

1203 East 12th Street, Streator, Illinois 61364

Phone: (815) 672-1645 Fax: (815) 672-1443

TRUST YOUR SOURCE ACCEPT NO SUBSTITUTIONS



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023679

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Benteler Steel & Tube-Germany

CUSTOMER P.O.	CUSTOMER PART	QUANTITY	LADING NO	CERT ID / REV	CERT DATE								
3887	SQ-N34035			/									
PART DESCRIPTION SHSQ0750035J300 Square OD Side1: 0.7500 Max:0.7600 Min:0.7400 Side2: 0.7500 Max:0.7600 Min:0.7400 Wall: 0.0350 Max:0.0380 Min:0.0320 Length: 12.00/26.00 Spec: AISI 304 Seamless Aircraft Grade: 4130 Anneal: Cond N													
CERTIFICATION REQUIREMENTS FAR BAA (FAR 52.225-1 Buy America Act Supplies). DFARS 252.225-7001 Buy America Act & Bal. of Payments Program FAR TAA (FAR 52.225-5 Trade Agreements)(Paragraph 1,3,4,5) This material was Eddy Current tested and conforms to the requirements of ASTM A-450. The Grain size is state defined and reported by the raw material supplier in accordance to ASTM E-112. This raw material was magnetic particle inspected by the raw material supplier in accordance to AMS 2640J and/or ASTM E-1444, and rated as Frequency, and Severity to AMS 2301, latest revision. Yield is determined using the 0.2% offset method. Additional Specifications - AMS-T 6736B, 6360P & 6371L. Material produced in accordance to ASTM A-515-17 and MIL-T 6736B. This material meets Plymouth ProMoly specifications. Jominy results: J(5/16")=45 J(8/16")=38													
Chemical Analysis													
C	Mn	P	S	Si	Al	Cr	Mo	Ni	Pb	Cu	V	Ti	Sn
.310	.55	.011	.002	.230	.036	.87	.18	.12	.001	.16	.002	.002	.010
Physical Properties													
Freq.	Severity	Grain Size											
.020	.015	9											
Mechanical Properties													
TEST	UNITS	#TESTS	HIGH	LOW	AVERAGE	STD. DEV							
Tensile	Psi	6	126660	125480	126765	482							
Yield	Psi	6	120930	119880	120387	374							
Elongation	%	6	21	20	20	1							
Rockwell C	Rc	6	25	25	25	0							
TEST	RESULT												
Decarb/OD	Pass												
Total ID/OD discard	Pass												

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streator in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Jamie Berossuff
Quality Assurance



PLYMOUTH TUBE CO.

1209 East 12th Street, Streator, Illinois 61364

Phone: (815) 673-1515 Fax: (815) 672-7343

TRUST YOUR SOURCE! ACCEPT NO SUBSTITUTIONS!



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023679

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Benteler Steel & Tube-Germany

CUSTOMER P.O. 3887	CUSTOMER PART SQ-N34035	QUANTITY	LADING NO	CERT ID / REV /	CERT DATE
PART DESCRIPTION SHSQ0750035J300					
Additional Specification(s)					
<u>TEST</u> Brinell	<u>UNITS</u> Brinell	<u>#TESTS</u> 6	<u>HIGH</u> 253	<u>LOW</u> 253	<u>AVERAGE</u> 253
					<u>STD-DEV</u> 0
<p>This test report data is for the heat Chemistry Stated above.</p> <p>The material in this test report is:</p> <ol style="list-style-type: none"> 1) Drawn in the USA 2) Free from Polybrominated Biphenyls (PBB), Polybrominated Diphenyl Ethers (PBDE), and Mercury contamination. 3) N-FTA compliant. <p>End of Certification</p>					

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streator in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Janine Baross
Quality Assurance

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M4130NTS 0.750W.035 PO / BATCH NO.: PUMB045594
 DATE: JAN 27 2020 5250794

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 609 PL
 QUANTITY INSPECTED: 609 PL
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .750W.035
 THICKNESS RECEIVED: .750W.035
 SHEET SIZE ORDERED: ---
 SHEET SIZE RECEIVED: ---

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL PER M-DRAWING	(Y)	N	MIL-T-6736
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT REF # TO LINK CERT	(Y)	N	616506
CORRECT MATERIAL IDENTIFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

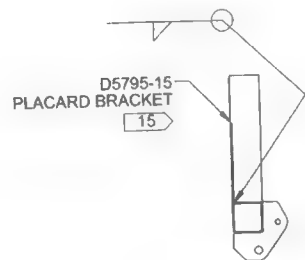
CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

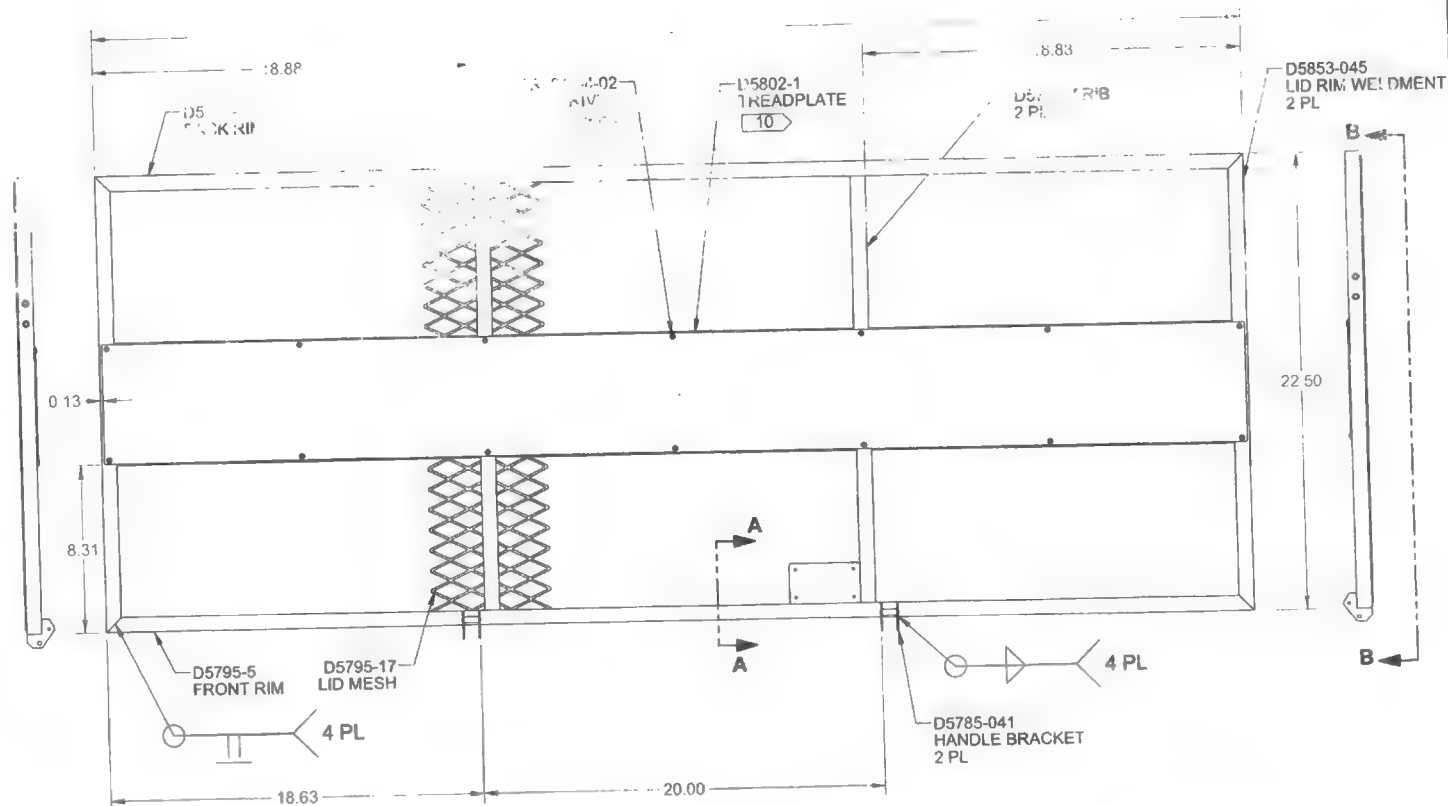
QC 18 INSPECTION		ENGINEERING SIGN OFF (if required)
INSPECTED BY: _____	DAS 32	SIGNED OFF BY: _____
DATE: <u>JAN 27 2020</u>	9-89	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received

QTY -041	P/N	DESCRIPTION
1	D5795-041	SHORT LID ASSY
1	D5795-041	HANDLE BRACKET
1	D5795-041	FRONT RIM
1	D5795-041	RIB
1	D5795-041	STRINGER
4	D5795-15	PLACARD BRACKET
1	D5795-17	LID MESH
1	D5802-1	TREADPLATE
2	D5853-045	LID RIM WELDMENT
14	CR3213-4-02	RIVET



SECTION A-A
SCALE 2X



D5795-041 SHORT LID ASSY
(DERIVED FROM AERO DESIGN P/N 77612-01)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 14.14 lbs
- 8) WELD PER DART QSI 004. IT IS PERMISSIBLE TO BUFF OR GRIND TO CLEAN UP WELDS
- 9) DRILL #30 (Ø 0.129) VENT HOLES AS REQUIRED. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD PRIOR TO FINISH.
- 10) INSTALL TREADPLATE AFTER FINISH. TRANSFER MARK AND DRILL HOLES Ø 0.129 +0.003 / -0.000 FROM TREADPLATE TO LID. FAY SEAL TO SURFACES BETWEEN LID AND TREADPLATE WITH RTV SILICONE. SECURE TREADPLATE WITH RIVETS.
- 11) WELD EVERY MESH INTERSECTION ALONG RIM.
- 12) FOR EACH RIB, WELD FIRST 5 MESH INTERSECTIONS DOWN EACH END, THEN EVERY 2ND MESH INTERSECTION MINIMUM.
- 13) FOR EACH STRINGER, WELD EVERY 2ND MESH INTERSECTION MINIMUM.
- 14) ALIGN STRINGERS TO TOP OF LID.
- 15) LOCATE D5795-15 PLACARD BRACKET FLUSH WITH BOTTOM OF LID. TRIM MESH TO CLEAR BRACKET LEAVING 0.25 OVERLAP. WELD MESH TO BRACKET.

RELEASED

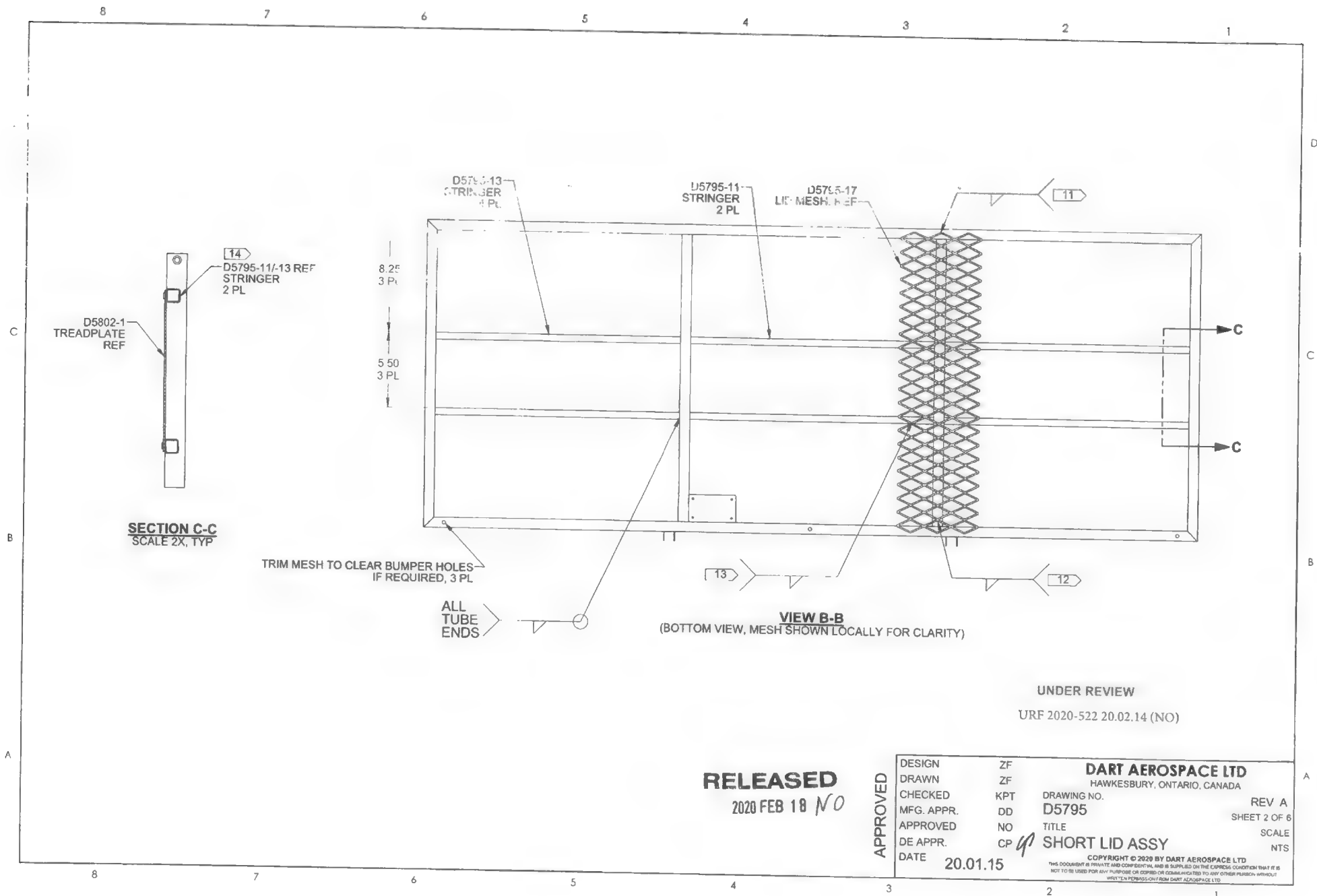
2020 FEB 18 NP
E C W 2020 - 521

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

APPROVED

REV	NEW ISSUE	DESCRIPTION	ZF	20.01.15
DESIGN	ZF		BY	DATE
DRAWN	ZF			
CHECKED	KPT			
MFG. APPR.	DD			
APPROVED	NO			
DE APPR.	CP			
DATE	20.01.15			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D5795**
REV. A
SHEET 1 OF 6
TITLE **SHORT LID ASSY**
SCALE
NTS
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UNDER REVIEW

URF 2020-522 20.02.14 (NO)

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2020 FEB 18 NO

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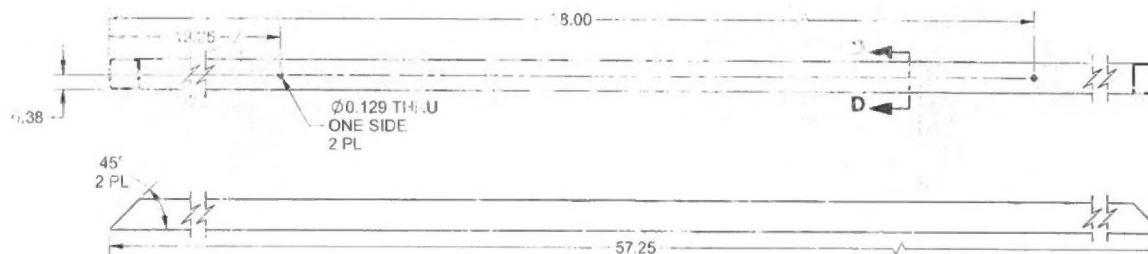
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DRAWN ZF
CHECKED KPT
MFG. APPR. DD
APPROVED NO
DE APPR. CP
DATE 20.01.15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D5795
TITLE SHORT LID ASSY
REV A
SHEET 2 OF 6
SCALE
NTS

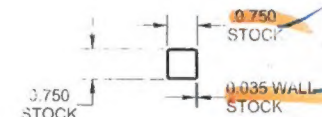
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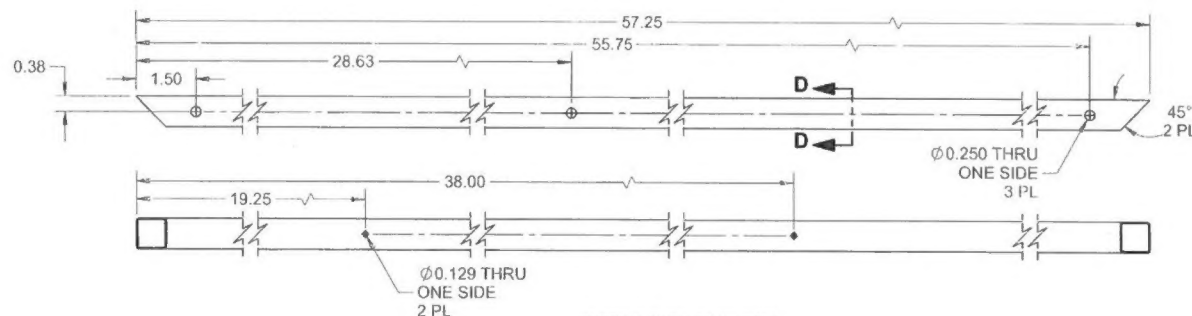


D5795-3 BACK RIM



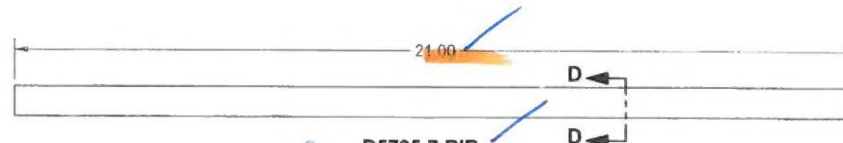
SECTION D-D

C



D5795-5 FRONT RIM

B



D5795-7 RIB

DAS
9
9-89

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF DART SPEC M4130N-TS0.750W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -3/-5: 1.55 lbs
-7: 0.58 lbs

RELEASED

2020 FEB 18 NO

APPROVED

DESIGN	ZF
DRAWN	ZF
CHECKED	KPT
MFG. APPR.	DD
APPROVED	NO
DE APPR.	CP
DATE	20.01.15

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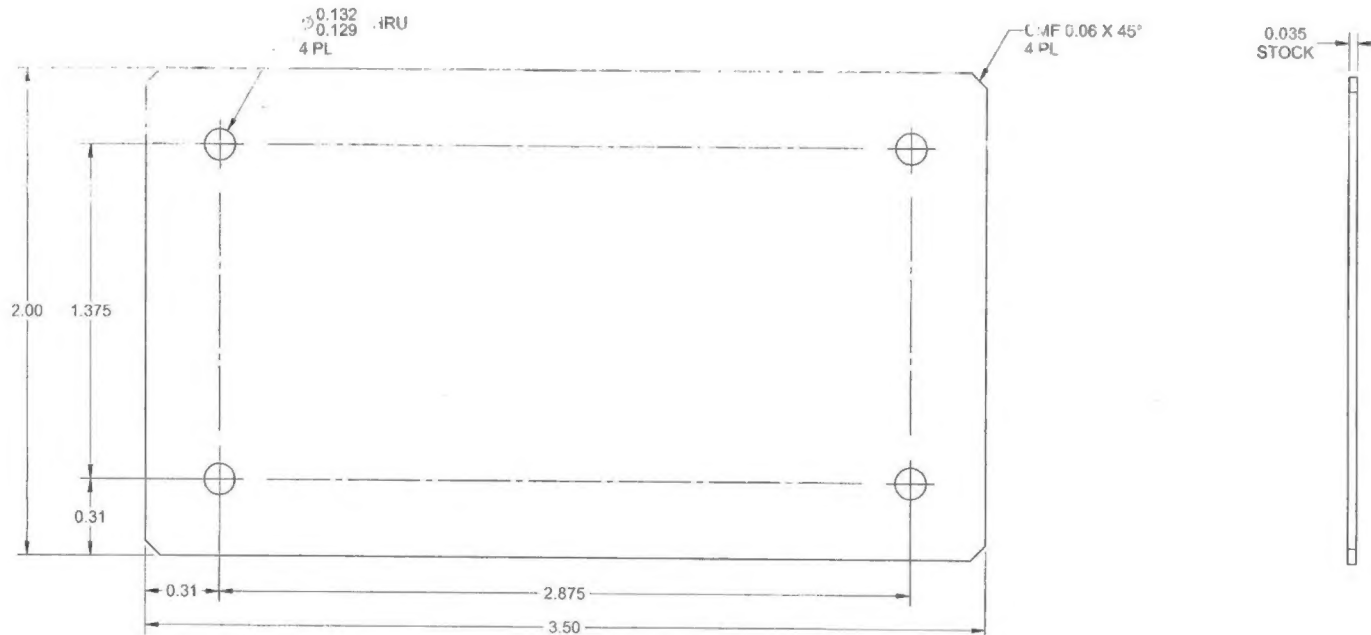
DRAWING NO.
D5795

TITLE
SHORT LID ASSY

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SHEET 3 OF 6
SCALE
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D5795-15 PLACARD BRACKET
(DERIVED FROM AERO DESIGN P/N 36204-10)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #20GA (0.035 THICK)
PER ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W
REF DART SPEC M1010-S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

RELEASED
2020 FEB 18 *Wd*

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DESIGN	ZF
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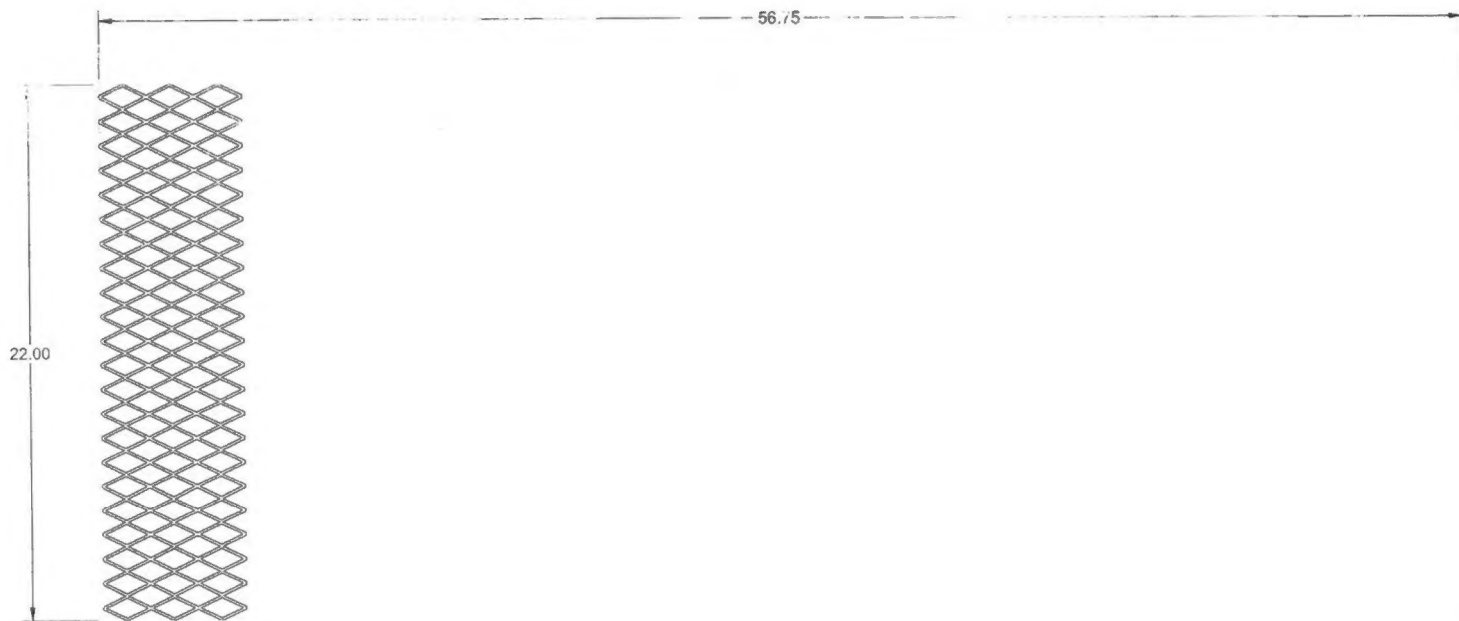
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D5795-17 LID MESH
(MESH SHOWN LOCALLY FOR CLARITY)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: CARBON STEEL EXPANDED METAL MESH 3/4-16F
PER ASTM F1267 OR MIL-M-17194D
REF DART SPEC M569EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.56 lbs

RELEASED

2020 FEB 18 *NO*

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CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5795	SHEET 6 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<i>4P</i> SHORT LID ASSY	NTS
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